

Page 1

May-01-12 10:36:34 AM

Setup Start *NS1*

Stop *NS2*

Customer:

Reference:

Run	Start	*NR1*
	Stop	*NR2*

100	FLOW WATER JET	0.00			
100					
Waterjet	Memo	0.00	30	0	Jm/S
FLOW CNC Waterjet	1-Cut as per Dwg D3041				12-5-12
6061.187 X 4.	Dwg Rev: 5				
	Prog Rev: 3				
	2-Deburr if necessary				
110	QC2- Inspect parts off machine FAI/FAIB	0.00			
110					
QC	Memo	0.00	30	0	Jm/S
Quality Control					12-5-12
120	QC8- Inspect parts - second check	0.00			
120					
QC	Memo	0.00	30		12 05 14
Quality Control					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83998

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 01/05/2012 **Start Qty:** 30.00

30

Customer:

Required Date: 15/05/2012 **Req'd Qty:** 30.00

30

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

130

Identify as per dwg & Stock Location: WMA

0.00

130

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/5/15 *[Signature]*
ME 12-05-15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83998

83998

Parent Item: D3040-3

D3040-3

Parent Item Name: Mounting Lug

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: B01.11.08 Revised Step 2 and Added Inspection Level 21SM
IPP Rev:A Now on Waterjet 07-03-07 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased	No			100	f	47.8900	0.3541	11.18211			

M6061T6B0 187X04 000

**

6061-T6 Bar .187 x 4.00

Location

Loc Qty

Loc Code

MAT001

47.89

119581

7.89

121282

40

119581

JM
12-5-12

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Dart Aerospace Ltd

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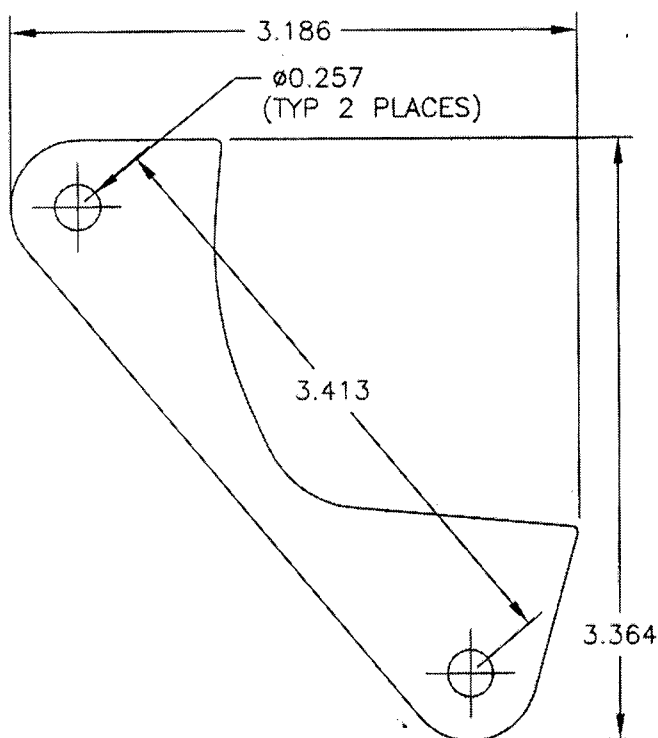
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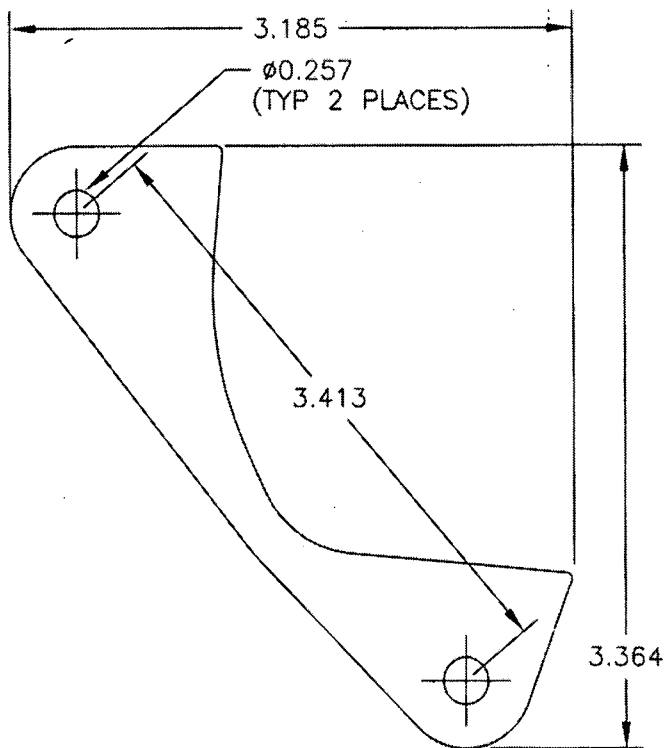


DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3040	REV. B SHEET 1 OF 1
DATE 01.09.04		TITLE MOUNTING LUG	SCALE 1:1
A	01.06.27	NEW ISSUE	
B	01.09.04	CHANGED PROFILE 5 DEGREES	

RELEASED
01.09.07



D3040-1



D3040-3

NOTES

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK (REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 83998
MCS
12/05/01

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Dart Aerospace Ltd

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